



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68951**

Tuesday, April 26, 2011 10:44:06 AM



Page 2

Item ID: D3502-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00		2 11-08-22					
QC Quality Control	Memo	0.00							
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Mark hole position using DT9430□Drill as per Dwg D3502.								
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							

ES 11/08/23 (2)

12X0 M-11/08/24

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# Work Order ID 68951

Tuesday, April 26, 2011 10:44:06 AM



Page 3

Item ID:	D3502-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support					
Start Date:	4/26/2011	Start Qty:	12.00			
Required Date:	5/24/2011	Req'd Qty:	12.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<div> <div>M 117745</div> <div> <div>Memo</div> <div>START TIME: 3:45</div> <div>FINISH TIME: 4:15</div> <div>OVEN TEMPERATURE: 3200F</div> </div> </div>									
170  QC Quality Control	QC3- Inspect Part Finish	0.00							
<div> <div></div> <div> <div>Memo</div> </div> </div>									
180  Packaging Packaging	Identify as per dwg & Stock Location: ST 63	0.00							
<div> <div></div> <div> <div>Memo</div> </div> </div>									

12X Ø M-L 11/08/24

12 BR 11-8-24

SP

12x Ø 11-08-24

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**NOTE:** Date & initial all entries

**Work Order ID 68951**

Tuesday, April 26, 2011 10:44:06 AM



Page 4

Item ID: D3502-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 4/26/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

C21108125

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# Picklist Print

Tuesday, April 26, 2011 10:44:13 AM

Page 1

Work Order ID: 68951



Parent Item: D3502-1



Parent Item Name: Support

Start Date: 4/26/2011

Required Date: 5/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-07-06 JLM  
IPP Rev:B Add tooling hole 07-03-28  
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	26.3100	0.289	3.650526			



6061-T6 Bar 1.00 x 4.00

Location

Loc Qty

Loc Code

MAT004

26.31

✓107221

22.23

114352

2.58

116808

1.5

3.6505<sup>FK</sup>

B.A 11/08/19

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SHOP COPY

RETURN TO

ENGR

UNCONTROLLED

SUBJECT TO AMENDMENT

WITHOUT NOTICE

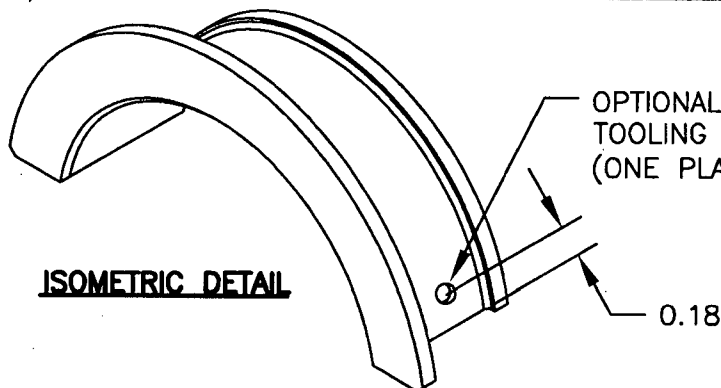
WORK ORDER

**DART**

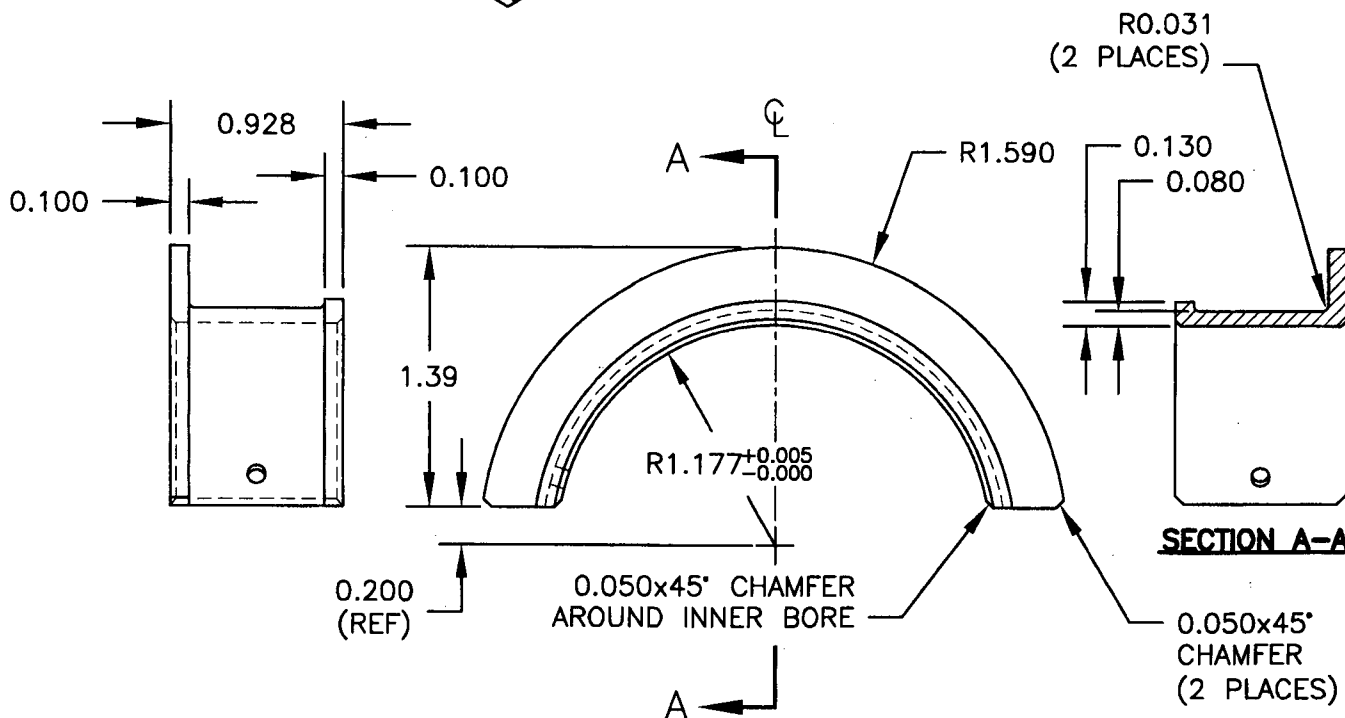
DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT SCALE 1:1		
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

NO. 68951

*11-04-26*



**RELEASED**  
06.12.06 *qp*  
PER ECN 585



## D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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